Work Orde Thursday, Janua			·.								Page 1
Item ID: Revision ID:	D3296-1			Accept				s	etup Si	tart	
Item Name:	Door Panel					, .			S	top	
Required Date:	1/6/2011 1/13/2011	Start Qty: 8.00 Req'd Qty: 8.00	11848 184 188 1848 184 184		Cust Item II Customer:	D:		• ,			
Approvals:	Process Pla	n:	Date://-0/- (Da			F		tart	
	QC:		Date:	SPC (Y/N):	Da	te:					
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	t Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3296	Rev	Α									
Waterjet FLOW CNC Waterje		FLOW WATER JET Memo 1-Cut as p Deburr if t	er Dwg D3296 □Dwg Rev necessary	0.00 0.00 : A □Prog Rev:_	<u>A</u> = 2-			<u> 18(1</u> -	<u> 4 – 1</u>)
QC Quality Control		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				BU	<u>- [-[</u>	<u></u>	<u> </u>
120 	·	QC8- Inspect parts - se	cond check	0.00	مرارح			(+11)			

Quality Control

Dart Aei	rospace	e Ltd							
W/O:		·	W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositio	QA: N/C C					
NCR:		`	WORK ORD	ER NON-CONFORMAI	NCE (NCF	₹)		M 1 2 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	n B Sign (& Sec	cation ion C	Approval Chief Eng	Approval QC Inspector

Work Order ID 65083

Thursday, January 06, 2011 9:52:54 AM



Page 2

Item ID:

D3296-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Door Panel

Start Date:

1/6/2011

QC:

Start Qty: 8.00

Required Date: 1/13/2011

Req'd Qty: 8.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:_____ Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Date:

Run

Reject

Oty

Accept

Qty

Start

Stop

Reject



Number Stamp

Insp.

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

140

HandFinish

Hand Finishing

Operation Description

Small Fab

Memd Deburr

0.00

0.00

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

150

Quality Control

QC3- Inspect Part Finish

Memo

0.00

11 BR 11-01-13

0.00

W/O:	· ·		WC	RK ORDER CHANG	FC						
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _			
					QA: N/C Closed: Date:						
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCF	₹)					
DATE	STEP	Description of NC		ion B	Verific	cation	Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	J JCCHOILC		Chief Eng	QC Inspector		
						,					
		•							.		
	1 1		1						1		

Work Order ID 65083

Thursday, January 06, 2011 9:52:54 AM



Page 3

Item ID:

D3296-1

Accept

Setup Start

Stop



Revision ID:

Door Panel Item Name:

Start Date: 1/6/2011

Start Oty: 8.00

Req'd Oty: 8.00 Required Date: 1/13/2011

Cust Item ID: Customer:

Reference:

A	nn	r0	va	le.	
A	DU	TU	٧a	15:	

Process Plan:

Date:

Tooling:

Date:

Tool ID

Run

Start

Stop



Date:

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Code

Accept Reject Otv Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Run Hours

0.00

0.00

170

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

U livlig

Dart Aeı	rospace	Ltd						
W/O:			W	ORK ORDER CHANGE	S		7	
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Dispositi	on:	QA: N/C Cld	sed:	Date: _	
NCR:		\	WORK ORI	DER NON-CONFORMA	NCE (NCR)		
5.475	0750	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	3	Verification	Approval	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng					
							- //					

Picklist Print

Thursday, January 06, 2011 9:52:57 AM

Work Order ID: 65083

Parent Item: D3296-1

Parent Item Name: Door Panel

| 1867 | 1970 | 1971 | 1974 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 | 1975 |

Start Date: 1/6/2011

114351

Required Date: 1/13/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP C□05.10.14□Added step 14□KJ/EC□ IPP Rev:D Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prima Item Locati	•	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No		100	sf	70.5000	0.6596	5.554526	, 7, <u>2</u>	2	

 Location
 Loc Oty
 Loc Code

 MAT22
 70.5

 114351
 70.5



Dart Aeı	ospace l	_td					ţ		_		
W/O:		······································	WORK ORDER CHANGES								
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector ×		
								9	(B)		
***************************************								, *			
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:			
	Res	solution:	Dispositio	n:	_ QA: N/C C	losed:		Date:			
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NCF	₹)					
		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	& Sect	on C	Chief Eng	QC Inspector		

DART AEROSPACE LTD	Work Order:	05083
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296 Rev: A		Page 1 of 1

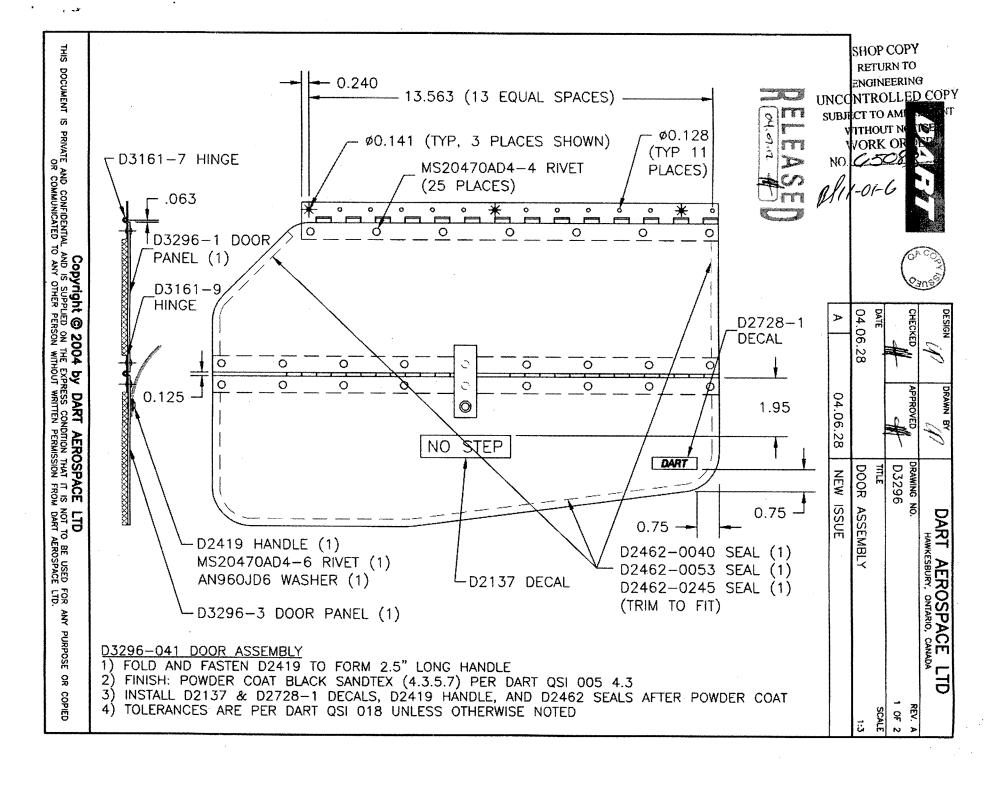
FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension	<u> </u>	_	Inspection	
5.08	+/-0.030	5.688	×		VBOZ	
R0.06	+/-0.030	ماه،	>		R.G.	
0.300	+/-0.010	\302	Ser		V	
Ø0.128	+0.005/-0.000	,131	8	•	V	
16.400	+/-0.005	16.400	4		T 1801	
0.300	+/-0.010	.300	6		V	
13.400	+/-0.005	13,400	×		7	
17.00	+/-0.030	17,00	8		4	
14.18	+/-0.030	14.18)er		1	·
0.300	+/-0.010	.303	2		V	`
0.063	+/-0.010	إدراب ك	xe		V	
			,	-		
		-				
	,					
			-			

Measured by: 3	Audited by:	Prototype Approval:	N/A
Date: 11-1-12	Date: 11/01/12	Date:	N/A

Rev	Date	Change		Revised by	Approv <i>e</i> d
Α	04.08.24	New Issue	P/O D3296-041	 KJ/JLM	
					7,0,7

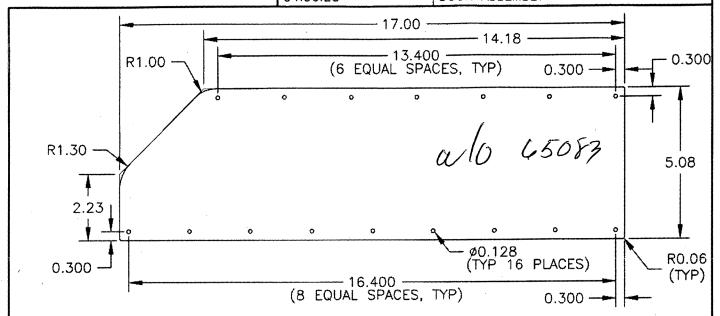


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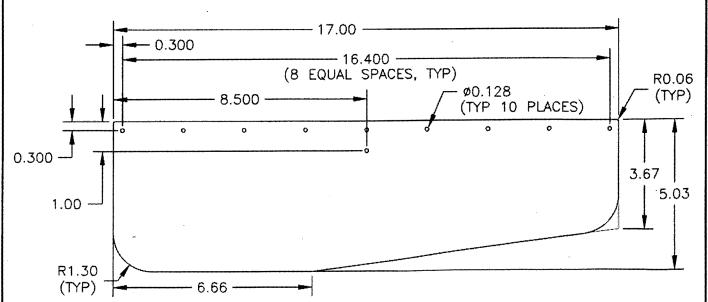




١	DESIGN A DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
	CHECKED	APPROVED	DRAWING NO.	REV. A		
	#	│	D3296	2 OF 2		
	DATE		TITLE	SCALE		
	04.06.28		DOOR ASSEMBLY	1:3		



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF DART SPEC. M2024T3S.063)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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